

# Work Order ID 68159

Thursday, April 07, 2011 11:01:02 AM

Page 1

Item ID: D412-711-021

Accept

Revision ID:

Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011 Start Qty: 1.00

Required Date: 4/8/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: *mf*

Date: *1-4-08*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D412-711

G

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefiles and create labels per PPP D412-711-021 CHG001

*S m04/08*

120

0.00



Pick Kit

Purchasing

Packaging

Memo

0.00

Packaging

*Rec'd 4/7 01*

130

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*S m04/08*

*(+)*

**Work Order ID 68159**

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Item ID: D412-711-021

Accept

Setup Start

Revision ID:

Stop

Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-711-021

Location:

PPP rev: DNDP

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 4/04/08

mf

11-04-08

# Picklist Print

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Work Order ID: 68159

Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-761-043 Modified Latch Mechanism, LH	CH1001	Manufactured	No			120	Each	0.0000	1	68164			
D412-711-101 Replacement Bubble Window	CH1002	Manufactured	No			120	Each	2.0000	1				

Location	Loc Qty	Loc Code
FG091	2	
67081	2	

D3802-1-120 Window Seal		Manufactured	No			120	Each	0.0000	1	68167			
D4165-1 Doubler		Manufactured	No			120	Each	0.0000	1	68120			
D4165-3 Inner Door Panel		Manufactured	No			120	Each	0.0000	1	68121			
D4165-5 Aft Rib		Manufactured	No			120	Each	0.0000	1	68125			
D4165-7 Fwd Rib		Manufactured	No			120	Each	0.0000	1	68122			
D4165-9 Angle		Manufactured	No			120	Each	0.0000	1	68123			

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Work Order ID: 68159

Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification



Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4165-11 Manufactured No 120 Each 0.0000



Door Cover Panel

68/24

D4207-1 Manufactured No 120 Each 0.0000



Window Retainer

68/33

D4207-3 Manufactured No 120 Each 0.0000



Instrument Window

68/34

D4269-1 Manufactured No 120 Each 0.0000



Angle

68/28

D4269-3 Manufactured No 120 Each 0.0000



Angle

68/28

D4269-5 Manufactured No 120 Each 0.0000



Angle

68/29

D4269-7 Manufactured No 120 Each 0.0000



Angle

68/30

D4324-041 Manufactured No 120 Each 0.0000



Armrest Assembly

68/46

D4324-043 Manufactured No 120 Each 0.0000



Arm Support Assembly

68/47

D4327-1 Manufactured No 120 Each 0.0000



Angle

68/52

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Work Order ID: 68159

Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

S	D4327-3	Manufactured	No	120	Each	0.0000	1	68153	C
	Angle								
S	D4385-1	Manufactured	No	120	Each	0.0000	2	68141	C
	Placard								
S	AN3-3A	Purchased	No	120	Each	332.0000	22		C
	Bolt								

Location	Loc Qty	Loc Code
ST350	332	
116419	32	
116924	300	

S	AN3-4A	Purchased	No	120	Each	100.0000	20	20	116915	C
	Bolt									

Location	Loc Qty	Loc Code
ST350	100	
117317	100	

S	AN3-6A	Purchased	No	120	Each	212.0000	26	26	114941	C
	Bolt									

Location	Loc Qty	Loc Code
ST351	212	
114941	62	
116191	50	
116704	100	

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Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-12A

Purchased

No

120

Each

121.0000

1

Bolt

Location

Loc Qty

Loc Code

ST351

121

114536

21

116786

100

120

Each

414.0000

92 92

NAS1149F0332P

Purchased

No

WASHER

Location

Loc Qty

Loc Code

ST275

414

17317

400

18057

14

120

Each

100.0000

34 34

CR3242-4-2

Purchased

No

Rivet

Location

Loc Qty

Loc Code

ST312

100

116583

100

120

Each

3,389.000

135 135

MS20426AD3-3

Purchased

No

Rivet

Location

Loc Qty

Loc Code

ST316

3389

19099

3389

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Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-3

Purchased

No

120

Each

4,537.000

140

140



Rivet

Location

Loc Qty

Loc Code

ST317

4537

113064

4537

120

Each

9,664.000

25

25

MS20470AD3-3

Purchased

No



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

9664

1065

1435

16941

8229

120

Each

6,187.000

90

90

MS20470AD4-3

Purchased

No



Rivet - Universal Head

Location

Loc Qty

Loc Code

MEZZ

6187

1642

1553

2193

4634

120

Each

2,045.000

24

24

MS21042L3

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

2045

116391

445

116540

800

116549

800

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Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS21059L3

Purchased

No

120

Each

19.0000

4 4



Nut Plate

Location

Loc Qty

Loc Code

ST302

19

116706

19

120

Each

100.0000

34 34

MS21069L3

Purchased

No



ANCHOR NUT

Location

Loc Qty

Loc Code

ST302

100

103447

30

112314

20

115708

50

120

Each

76.0000

8 8

MS21069L08

Purchased

No



ANCHOR NUT

Location

Loc Qty

Loc Code

MEZZ

76

102587

76

120

Each

97.0000

3 3

MS21071L3

Purchased

No



ANCHOR NUT

Location

Loc Qty

Loc Code

ST302

97

102587

47

114348

50

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Work Order ID: 68159



Parent Item: D412-711-021



Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS21071L08

Purchased

No

120

Each

186.0000



ANCHOR NUT

*Signature* 11/4/80

Location

Loc Qty

Loc Code

MEZZ

186

102587

86

103447

100

102087

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# REFERENCE ONLY

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
1	1	1	1	1	X			D412-711-021	VERTICAL REFERENCE DOOR KIT
						X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
					1	1		D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1	1		D412-711-101	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1	1		D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1	1		D4165-1	DOUBLER
					1	1		D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1	1		* D4165-5	AFT RIB (REPLACES EA20469-34)
					1	1		** D4165-7	FWD RIB (REPLACES EA20469-31)
					1	1		D4165-9	ANGLE (REPLACES EA20469-17)
					1	1		D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1	1		D4207-1	WINDOW RETAINER (REPLACES EA20469 -14)
					1	1		D4207-3	WINDOW (REPLACES EA20469-13)
					1	1		* D4269-1	ANGLE (REPLACES EA20469-33)
					1	1		** D4269-3	ANGLE (REPLACES EA20469-30)
					1	1		** D4269-5	ANGLE (REPLACES EA20469-29)
					1	1		* D4269-7	ANGLE (REPLACES EA20469-32)
					1	1		*** D4324-041	ARM REST ASSEMBLY
					1	1		*** D4324-043	ARM SUPPORT ASSEMBLY
					1	1		D4327-1	ANGLE (REPLACES EA20469-11)
					1	1		D4327-3	ANGLE (REPLACES EA20469-07)
					2	2		D4385-1	PLACARD

\* PART OF EA20469-10 REAR RIB ASSEMBLY  
 \*\* PART OF EA20469-12 FWD RIB ASSEMBLY  
 \*\*\* PART OF EA20469-16 ARM REST ASSEMBLY

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D412-711</b> TITLE <b>VERTICAL REFERENCE DOOR</b> SCALE <b>NTS</b> <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
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CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.03.31	

REV. G  
 SHEET 2 OF 6

# REFERENCE ONLY

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	PART NUMBER	DESCRIPTION
					22	22	AN3-3A	BOLT
					20	20	AN3-4A	BOLT
					26	26	AN3-6A	BOLT
					1	1	AN3-12A	BOLT
					92	92	NAS1149F0332P	WASHER (OR AN960-10L)
					34	34	CR3242-4-2	RIVET
					135	135	MS20426AD3-3	RIVET
					140	140	MS20426AD4-3	RIVET
					25	25	MS20470AD3-3	RIVET
					90	90	MS20470AD4-3	RIVET
					24	24	MS21042L3	NUT
					4	4	MS21059L3	NUT PLATE
					34	34	MS21069L3	NUT PLATE
					8	8	MS21069L08	NUT PLATE
					3	3	MS21071L3	NUT PLATE
					1	1	MS21071L08	NUT PLATE
A <sub>1</sub>	A <sub>1</sub>	A <sub>1</sub>	A <sub>1</sub>	A <sub>1</sub>		1	204-030-853-119	LH COPILOT DOOR
1							D412-711-111	WIRING HARNESS, 212/412
B <sub>1</sub>							B <sub>1</sub> D4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1						D205-711-113	WIRING HARNESS, 205
	B <sub>1</sub>						B <sub>1</sub> D4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1					D204-711-115	WIRING HARNESS, 204
		B <sub>1</sub>					B <sub>1</sub> EA20469-15-204	INSTRUMENT PANEL, 204
			1				D214-711-117	WIRING HARNESS, 214
			B <sub>1</sub>				B <sub>1</sub> EA20469-15-214	INSTRUMENT PANEL, 214
				1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
				B <sub>1</sub>			B <sub>1</sub> D4268-047	INSTRUMENT PANEL, EAGLE SINGLE

(A) CUSTOMER SUPPLIED

(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE

## NOTES

### 1) WIRING HARNESSES:

For Bell 204/205/210/214 Wiring Harnesses, use drawing D2046904.  
For Bell 212 Wiring Harnesses, use drawing D2046903.  
For Bell 412 Wiring Harnesses, use drawing D412-711-901.  
For Bell 212 modified per SH07-28/SR02831NY use D212-761-224  
or D212-761-225 depending on aircraft s/n.

Wiring Harnesses will vary  
depending on aircraft s/n.

### 2) D412-711-101 REPLACEMENT WINDOW:

To increase downward viewing clarity, it is acceptable to cut a small section from the replacement window on its downward side per Figure 1 of this document. The cutout can be a maximum of 9.00" wide x 17.00" long (229mm x 432mm), measured along the profile of the replacement window. The corners of the cutout must have a minimum radius of 2" (50mm). The cutout should be located at least 1.0" (25mm) from the flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 1 for reference.

### 3) D412-711-043 SNAP VENT KIT:

It is acceptable to install a total of up to 2X D3932-1 Snap Vents (available from Dart) onto the D412-711-101 Replacement Window to provide ventilation into the cabin. Refer to Figure 1 for acceptable locations and size of cutouts.

DESIGN	<del>1</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>1</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>1</del>	DRAWING NO.	REV. G
MFG. APPR.	N/A	<b>D412-711</b>	SHEET 3 OF 6
APPROVED	<del>1</del>	TITLE	SCALE
DE APPR.	<del>1</del>	<b>VERTICAL REFERENCE DOOR</b>	NTS
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